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RBW1805G01531-3G-1
Job Sheet 172693



Part No: RBW1805G01531-3G-1

Job Qty: 3 ea

Part Name: Mast Vibration Absorber Lift Base



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/21/18

Job Tracking No:

Due Date: 2/28/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG RBW1805G01531-3G REV 2 IPP Rev A 17.11.03 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	3 Ea	2/27/18	2/27/18	0.00	0.00	Start Up Machining-4		JB 18-04-17
100	Bandsaw	3 pcs	2/27/18	2/27/18	0.00	0.08	Bandsaw1		JB 18-04-17
110	Mori Seiki	3 pcs	2/27/18	2/27/18	0.50	0.75	MORI SL2500Y		JB 18-04-17
120	QC	3 pcs	2/27/18	2/27/18	0.00	0.00	QC2		JB mml 18/04/17
130	Lathe Conv	3 pcs	2/27/18	2/27/18	0.00	0.75	* Lathe Conv-2		JB 18-04-17
140	QC	3 pcs	2/27/18	2/27/18	0.00	0.00	QC2		JB mml 18/04/17
150	Mill Conv	3 pcs	2/28/18	2/28/18	0.00	0.75	Mill Conv 1		JB 18-04-17
160	QC	3 pcs	2/28/18	2/28/18	0.00	0.00	QC2		JB 18-04-17
170	QC	3 pcs	2/28/18	2/28/18	0.00	0.00	QC8		JB 18-04-18
180	Packaging	3 pcs	2/28/18	2/28/18	0.00	0.00	Packaging3		JB 18-04-18
190	QC21-SA	3 Ea	2/28/18	2/28/18	0.00	0.00	QC21		JB 18-04-18

Part Op 100 - Cut blank at 1.78"

Descriptions: 110 - Machine as per DWG. RBW1805G01531-3G-1 and Folio FB 927 Program Serial # 1 - Debur
130 - Face part to final length
150 - Mill side notches
160 - Engrave T/N And / or S/N number as required Using Marktronic engraver as per DWG.

DAS APR 18 2018
9-20

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304R2.000 M303	304 Round Bar 2.00	4500 ft (.15 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304R2.000	0	8	0

Part Specifications

Specifications could not be found.

Plex 2/21/18 11:59 AM Dart.Gagnon.Michelle

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

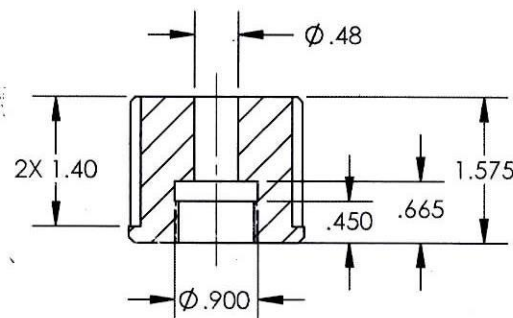
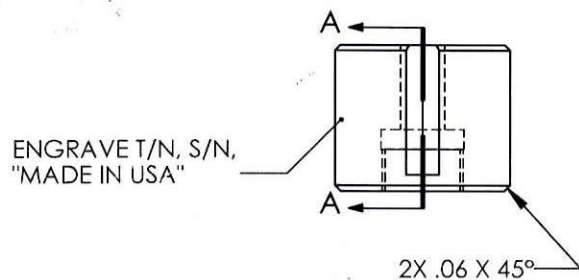
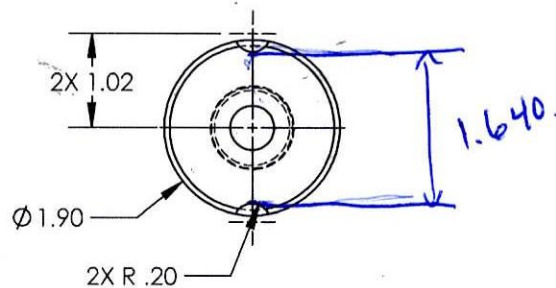
QA Closed: _____ Date: _____

Work Order update only ☐

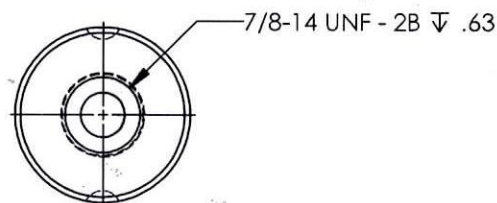
Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	15-0284	-1 CH'D DIM WAS Ø.477 IS Ø.48.	9/1/2015	RJC	JAG



SECTION A-A

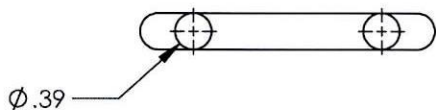
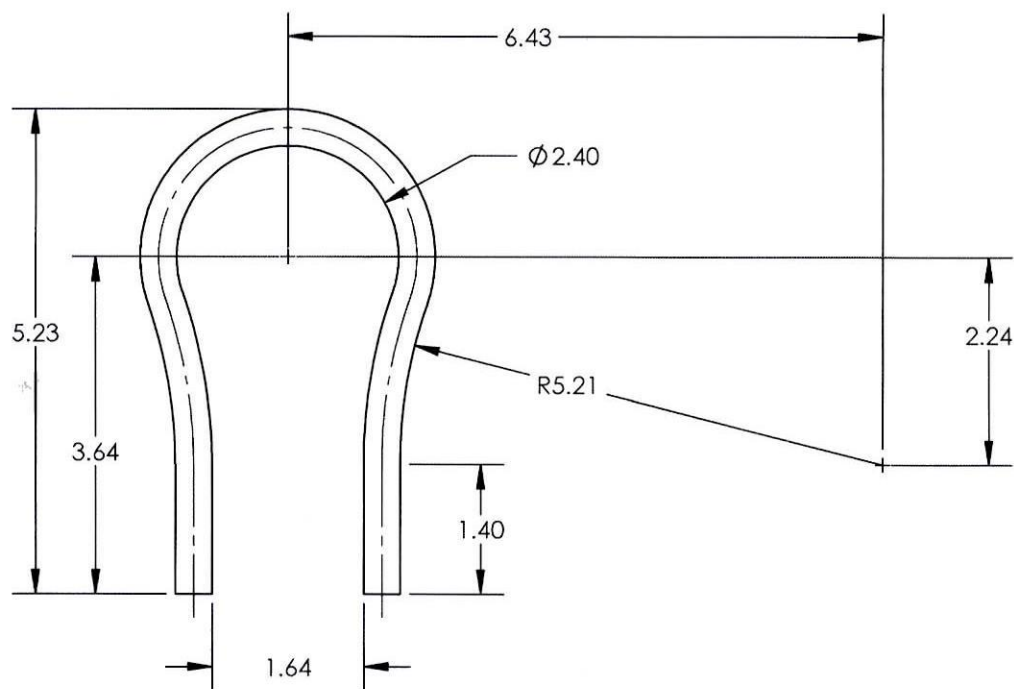


(-1)
MVA LIFT BASE

DART AEROSPACE	
TITLE MVA LIFTING TOOL	
DWG NO. RBW1805G01531-3G-1	REV 2
MAT'L S.S.	DRAWN BY: SMITH
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D. Wed</i>
.XXX ± .005 FRACTIONS ± 1/8	HEAT TREAT
.XX ± .01 ANGLES ± 5°	FINISH
.X ± .1	SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	AW139
SCALE 1:2	DATE 4/29/2013
SHEET 2 OF 3	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED



③

MVA LIFT HANDLE



DART AEROSPACE	
TITLE MVA LIFTING TOOL	
DWG NO. RBW1805G01531-3G-3	REV 2
MAT'L S.S.	DRAWN BY: SMITH
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 5° .X ± .1	APPROVED <i>D Weil</i>
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	HEAT TREAT
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	FINISH
	SPEC
	USED ON MODEL
	AW139
SCALE 1:2	DATE 4/29/2013
SHEET 3 OF 3	



Container No: S061754



Part: RBW1805G01531-3G-1

Job No: 172693

Serial No/Batch: S061754

Revision: 2

Inspector:

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Date: 04/17/18